Dart Aerospace Ltd. Tuesday, 8/28/2007 3:17:22 PM Kim Johnston User: **Process Sheet** : STRAP Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : 34291B Job Number **Estimate Number** : 10729 : NA : D23245 **Part Number** P.O. Number S.O. No. : NA : 8/28/2007 - D2324 REV C This Issue **Drawing Number** : N/A Prsht Rev. Project Number : SMALL /MED FAB : C **Drawing Revision** First Issue : 32872 Material **Previous Run** : 9/12/2007 40 Um: **Due Date** Written By Checked & Approved By E 03/02.28 Reformat; Incorporated D2324-3 & D2324-5 K : Est. Comment J/RF **Additional Product** Job Number: Machine Or Operation: Description: Seq. #: 1.0 M304S16GA 304/316 .063 Sheet Comment: Qty.: Total: 0.7360 sf(s)0.0184 sf(s)/Unit 304/316 .063 Sheet BH 105 130 FLOW WATER JET 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D2324 Dwg Rev:_ Prog Rev:_ 2-Deburr if necessary 3.0 QC2 Comment: DIMENSIONAL CHECK Inspect dimensions per template D2324-5T1 4.0 QC8 SECOND CHECK

Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary

Comment: SECOND CHECK

SMALL FAB 1

SAD 03/09/16

SMALL & MEDIUM FAB RESOURCE 1



40

Each

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No			PAR #·	Fault Category:	NCR: Yes		A. F	Date		

QA: N/C Closed: _____ Date: ____

NCR:		V	WORK ORDER NON-CONFORMANCE (NCR)								
DATE		Description of NC		Corrective Action Section B	Verification						
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
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NOTE: Date & initial all entries

Date: User* Tuesday, 8/28/2007 3:17:22 PM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRAP

Job Number: 34291B

Part Number: D23245

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

PACKAGING 1

PACKAGING RESOURCE #1





Comment: PACKAGING RESOURCE #1

Identify and Stock Location: \$\frac{1}{26}\$

7.0





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



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W/O:			WO	RK ORDER CHANGES	3			2	
DATE	STEP	PR	OCEDURE CHAI		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34291B
Description: Strut	Part Number:	D2324-5
Inspection Dwg: D2324 Rev: C		Page 1 of 1

FIRST / X Tolerance +/-0.030 +0.006/-0.001 +0.005/-0.001 +/-0.010 +/-0.010 +/-0.010	ARTICLE IN First Artic Actual Dimension RO.38 Ø 6.258 Ø 6.192 0.752 0.384		Proto		Comments
Tolerance +/-0.030 +0.006/-0.001 +0.005/-0.001 +/-0.010 +/-0.010	First Artic Actual Dimension RO.38 Ø 6.258 Ø 6.192 0.752 0.384	Accept	Proto	Method of Inspection R	Comments
+/-0.030 +0.006/-0.001 +0.005/-0.001 +/-0.010 +/-0.010	Dimension RO.38 Ø 6.258 Ø 6.192 0.752 0.384		Reject	Inspection R-E Vern	Comments
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108/31	Date:	07/04	B/3/L	Da	ate: N/A
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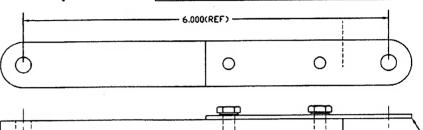
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Rev	Date	Change	······································		Revised by	Approved
A	06.06.05	New Issue			KJ/JLM حكي	



DES B	IGN WILLIAMS	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
	CKED	APPROVED.	DRAWING NO.	REV. C
	#	-#-	D2324 SHEET	1 OF 1
DAT	<u> </u>		TITLE	SCALE
04	.12.14		STRUT	
Α		94.11.08	NEW ISSUE	
В		96.05.07	UPDATE MATERIALS	
С		04.12.14	UPDATE NOTES	

D2324-5

RELEASED 04.12.16



AN3-12A BOLT (1) AN960JD10 WASHER (2) MS21042L3 NUT (1) (TWO PLACES) D2324-3 D2324 STRUT ASSEMBLY 1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

Ø0.191 (2) Ø0.257 R0.38 0.750 $(\mp$ 0.375 1.875 5.250 5.625 -

D2324-3

6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75 1) MATERIAL:

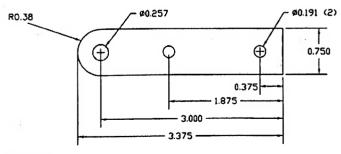
(REF DART SPEC. M6061T680.750X00.750)

ACID ETCH AND ALODINE PER DART QSI 005 4.1 2) FINISH:

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5

AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) 1) MATERIAL: (REF DART SPEC. M304S16GA)

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 2) FINISH:

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 34291